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CLAIMS

1. Tie-type security seal comprising a body of thermoplastic material (2) with a locking cavity in the form of a passage (7) through the body, a metallic insert element (11) fixed in said cavity and formed with at least one through-opening (15) aligned with said passage (7) and also a locking tooth (14), and an elongated strip of thermoplastic material (4) integral at one end with the body (2) and having another free end for insertion through said passage in a first direction where it is locked by said tooth (14) to prevent removal from the cavity in the opposite direction, the body and the strip having been manufactured by a plastic injection operation, characterized by the fact that the metallic insert element (11) has been incorporated into said body of thermoplastic material (2) during the injection operation.
2. Security seal according to claim 1, characterized in that the passage (7) that defines the cavity in the body (2) of the seal has a cross section substantially identical to that of the strip (4), at least in the greater part (8) of the length of the latter.
3. Security seal according to claim 2, characterized in that the free end portion (9) of the strip (4) has a smaller cross section than the remaining part of the strip to facilitate the initial introduction through said passage (7).
4. Security seal according to claim 1, 2 or 3, characterized in that the metallic insert element is a substantially flat part (11) stamped with a main region (13) cut out in its centre to define a plurality of teeth (14) bent outwardly from the plane of the part, defining an opening (15) between the ends of the teeth for passage of the strip (4), and, on each side and in the same plane as the central region (13), a lateral extension (12) of which the end coincides with the side of said body.
5. Security seal according to claim 4, characterized in that said end of each lateral extension (12) of the metallic insert element has the form of a two-pronged fork.
6. Security seal according to claim 4 or 5, characterized in that the end of each of said side extensions (12) is integral with a corresponding end of a side extension (12) of a metallic insert element (11) of another similar